

Work Order ID 119964

Wednesday, June 11, 2014 1:46:38 PM

119964

Page 1

Item ID: D206-642-114 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH, Low Gear with Run-on Landing Wearplates
 Start Date: 6/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/6/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference: PER NCR

Approvals: Process Plan: WLF Date: 14-6-11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								

150

0.00

150

HandFinish
Hand Finishing

Memo

PULL FROM STOCK D206-642-114:

- ☒ B105018
- ☒ B105343
- ☒ B107280
- ☒ B107281
- ☒ B110003

REWORK PER ATTACHED E-MAIL
D2651-3 X 6 B 113577 per tube

0.00

PLM 14-06-16

RTV 06/15 M115792

160

160

QC
Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

SHD
4/6/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Page 2

Item ID: D206-642-114

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Low Gear with Run-on Landing Wearplates

Start Date: 6/2/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: PER NCR

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
Packaging	Memo	0.00	JUN 18 2014	DAS	06				
Packaging	ENSURE ORIGINAL KIT IS IN BOX			9-89					
180	QC4- 100% Inspect kits for completeness	0.00							
180					DAS				
QC	Memo	0.00	JUN 18 2014	06					
Quality Control				9-89					
190		0.00							
190					DAS				
Packaging	Memo	0.00	JUN 18 2014	06					
Packaging	REPACKAGE USING ORIGINAL B/N			9-89					

F6083
All

DQA: _____ Date: _____



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Equip/Tooling									
Handling/Pre									
Material									
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Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 3

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Revision ID: Stop ***NS2***
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Start Date: 6/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/6/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference: PER NCR

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

QC21 - Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 1406-19

MLJ 1406-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
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Picklist Print

Wednesday, June 11, 2014 1:46:38 PM

Page 1

Work Order ID: 119964

119964

Parent Item: D206-642-114

D206-642-114

Parent Item Name: Skidtube RH,Low Gear with Run-on Landing Wearplates

Start Date: 6/2/2014

Required Date: 6/6/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER REV.N DD VERF:EC IPP REV:B
 11.09.23 ADDED K10112 DD VERF:EC IPP REV:C
 REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED
 BY:DD IPP Rev:D 12.11.21
 ECN12-679 DD verf:JLM IPP Rev:E 14.04.24 ECN14-520
 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2651-3		Manufactured	No				Each	546.0000		30			

D2651-3

O-Ring

Location

Loc Qty

Loc Code

FP001

546

104725

8

112214

44

113577

494

mf 14-6-19

DQA: _____ Date: _____



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Melanie Fauteux

From: Linda Lacelle
Sent: Thursday, May 29, 2014 1:31 PM
To: Patrick Smith; Mike Petsche
Cc: Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd; Melanie Fauteux
Subject: RE: 350 skids and 206 skids

Thx...when can all of these be done? Also, are the 205 also affected ?
LL

From: Patrick Smith
Sent: May-29-14 1:29 PM
To: Linda Lacelle; Mike Petsche
Cc: Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
Subject: RE: 350 skids and 206 skids

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

From: Linda Lacelle
Sent: May-29-14 10:21 AM
To: Mike Petsche
Cc: Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod
Subject: 350 skids and 206 skids
Importance: High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx

Linda

List Lots

Monday, June 02, 2014 9:19:53 AM

Page 1 of 1

Criteria : Item ID: D206-642-114 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-642-114 Skidtube RH, Low Gear Run On Landing	Main Warehouse FG082	105018	12/18/2013	1.0000	QC21	CHG003	
	Main Warehouse FG082	105343	12/18/2013	1.0000	QC21	CHG003	
	Main Warehouse FG082	107280	12/18/2013	1.0000	QC21	CHG003	
	Main Warehouse FG082	107281	12/18/2013	1.0000	QC21	CHG003	
	Main Warehouse FG082	110003	12/18/2013	1.0000	QC21	CHG004	
	OFFSHORE FG	95827	12/18/2013	1.0000	QC21	CHG003	
Total:				6.0000			

#119964
x6

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